



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9910

Job Sheet 177161



Part No: 646.9910

Job Qty: 12 ea

Part Name: Struts



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: 646.9900 rev nc1 IPP REV:A NEW ISSUE 12-09-19 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	6/5/18	6/5/18	0.00	0.00	Start Up Machining-1		M.P. 18/05/18
110	Doosan	12 pcs	6/5/18	6/5/18	0.00	2.36	Doosan		M.P. 18/05/18
120	QC	12 pcs	6/5/18	6/5/18	0.00	0.00	QC2 Machining-1		M.P. 18/05/18
170	QC	12 pcs	6/5/18	6/5/18	0.00	0.00	QC8 Machining-1		M.P. 18/05/18
180	Outsource	12 pcs	6/5/18	6/5/18			ATG001-VC		CL 18-5-29
190	Packaging	12 pcs	6/5/18	6/5/18	0.00	0.00	Packaging2		M.P. 18/06/15
200	QC	12 pcs	6/5/18	6/5/18	0.00	0.00	QC5		38
210	Packaging	12 pcs	6/5/18	6/5/18	0.00	0.00	Packaging3-1		JUN 21 2018
220	QC21-SA	12 Ea	6/5/18	6/5/18	0.00	0.00	QC21		JUN 21 2018

Part Op 110 - *** CUT BLANK ON CHOP SAW AT 24.030" LONG*** TURN AS PER DWG DWG REV: 225 FOLIO

Descriptions: REV: DEBURR

180 - Issue P/O to ATG : 800 40026 Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C

190 - Ensure certificate of conformity is attached

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.563	6061-T6 Round Bar .563	25.2000 ft (2.1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.563	25	115	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	0.563Inches $\pm$ 0.010	0.573 0.553		
2	Strut	0.190Inches $\pm$ 0.010	0.200 0.180		
3	Strut	0.275Inches $\pm$ 0.010	0.285 0.265		
4	Strut	24.000Inches $\pm$ 0.030	24.030 23.970		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

5	Strut	0.201Inches + 0.005 - 0.001	0.205 0.206 0.200
6	Strut	45.0Angle ± 0.5	45° 45.5 44.5

Plex 5/8/18 10:13 AM Dart.lajeunesse.marie



Container No: S075012



Part: 646.9910
Job No: 177161
Serial No/Batch: S075012
Revision: nc1
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/28/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040026**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040026

PO Date: 5/29/18

Due Date: 6/13/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, Chrisoula

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177613	649.5013	Deflector Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	5/31/18	19 pcs	0 pcs ✓ 19	19 pcs	\$16.10/pcs AT 18/05/31	\$305.90
Line Item Note ** URGENT part - need back Thursday **										
2	177164	649.5011	Deflector Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	5/31/18	10 pcs	0 pcs ✓ 10	10 pcs	\$15.00/pcs AT 19/05/31	\$150.00
Line Item Note ** URGENT part - need back Thursday **										
3	177161	646.9910	Struts Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed	6/13/18	12 pcs	0 pcs ✓ 12	12 pcs	\$17.90/pcs AT 18/06/15	\$214.80

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	176233	646.3813	AS350 Strut Bracket Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.3800	Firmed	6/13/18	12 pcs	0 pcs	12 pcs	\$10.60/pcs	\$127.20
5	177270	647.5710	GPS Mount Outsource process-Anodize per QSI017 4.1.10.1	Firmed	6/13/18	5 pcs	0 pcs	5 pcs	\$14.55/pcs	\$72.75
Grand Total:										\$870.65
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 5/30/18 11:27 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915389

Date: 14-Jun-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
12 ea	Part: 646.9910 Struts Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23189 PO: PO040026 Line: 3 Rev: NC		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>14/06/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			